

DO NOT
SCALE FROM
THIS PRINT

No OF POSITIONS
-026, -052, -078
(PER ROW)

SOLDER TAIL LEAD STYLE
-01: 1.57[.062] BOARD
*-02: 2.36[.093] BOARD

(* = NOT TOOLED)

OPTION
-K: POLYIMIDE FILM
(NOT AVAILABLE FOR
-026 & -078)
(USE K-500-300,
SEE FIG. 2, SHT 4)
-TR: TAPE & REEL
(SEE NOTE 10)

GUIDE POSTS REQUIREMENT
-GP (SEE NOTE 9)

RIGHT ANGLE
-RA

PLATING SPECIFICATION

-S: SELECTIVE, 30Au / 50Ni MIN ON
CONTACT, MATTE TIN ON TAIL
(USE C-288-XX-S & IM-T-1G36-XX-S)
-L: LIGHT SELECTIVE, 30Au / 50Ni MIN ON
CONTACT, MATTE TIN ON TAIL
(USE C-288-XX-L & IM-T-1G36-XX-L)

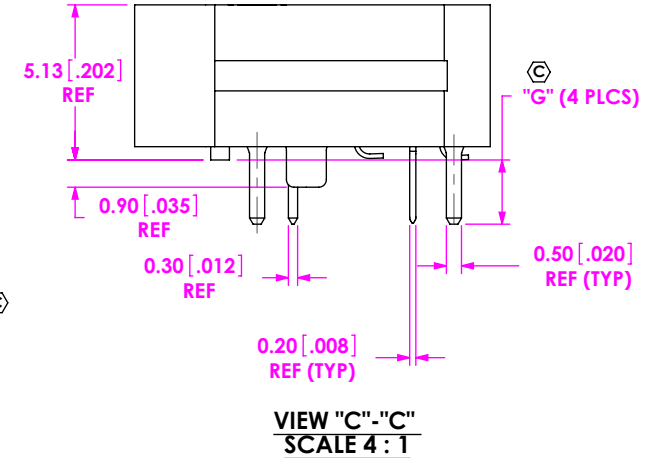
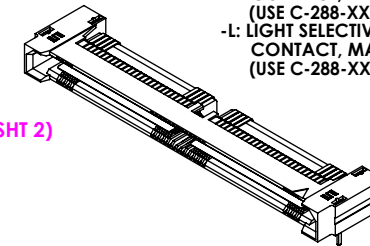
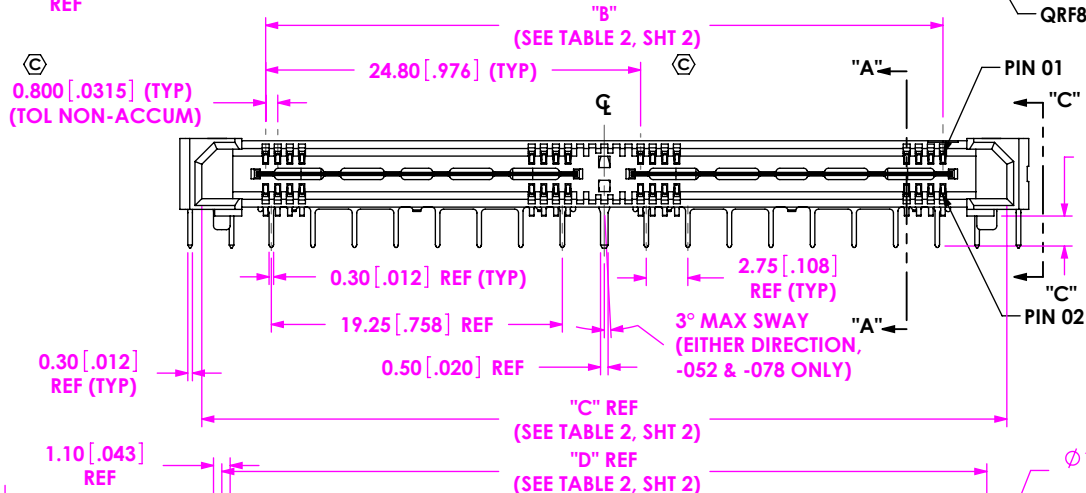
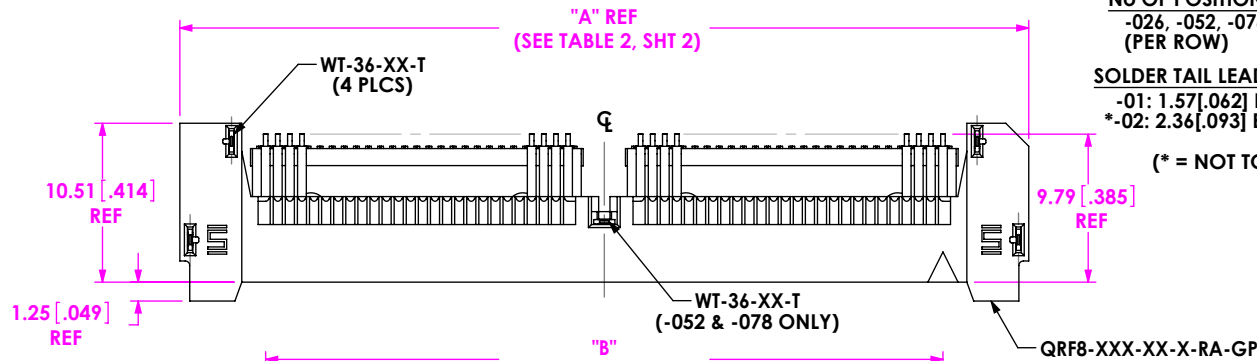


FIG 1
(QRF8-052-02-X-RA-GP SHOWN)
(SOME DETAIL REMOVED FOR CLARITY)

TABLE 1

LEAD STYLE	"OVER MOLDED GROUND PLANE"	"WELD TAB"
-01	IM-T-1G36-01-X	WT-36-01-T
*-02	IM-T-1G36-02-X	WT-36-02-T

(* = NOT TOOLED)

NOTES:

1. Ⓢ REPRESENTS A CRITICAL DIMENSION.
2. BURR ALLOWANCE: 0.038[.0015] MAX.
3. MINIMUM PUSHOUT FORCE: SIGNAL: 2.22N[.5 LB].
GROUND PLANE: 4.45N[1 LB].
4. NOTE DELETED.
5. MEASURE AT BEND TANGENCY.
6. MEASURE ON PINS ONLY, STANDOFFS NOT INCLUDED IN MEASUREMENT.
7. POST HEIGHT VARIATION BETWEEN ANY TWO PINS: 0.05[.002] MAXIMUM.
8. FIRST ROW TAILS TO BE FLUSH TO .08 ABOVE THE SECOND ROW.
9. PARTS WITH THE -GP OPTION MUST MATE TO -GP OPTIONED QRF8 PARTS.
10. PARTS TO BE PACKAGED IN TRAYS, UNLESS -TR OPTION IS SPECIFIED.
-078 POSITION IS NOT AVAILABLE IN TAPE AND REEL.
11. CPC'S MUST BE MEASURED BOTH ENDS OF COMB OR CONNECTOR.
12. USE INSPECTION FIXTURE # AT-2298-801-01 TO CHECK CRITICALS.

UNLESS OTHERWISE SPECIFIED,
DIMENSIONS ARE IN
MILLIMETERS [INCHES].
TOLERANCES ARE:
DECIMALS ANGLES
X.X: ±0.3 [.01] 2°
X.XX: ±0.13 [.005]
X.XXX: ±0.051 [.0020]

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MATERIAL: DO NOT SCALE DRAWING SHEET SCALE: 2:1
INSULATORS: LCP
CONTACT: PHOS BRONZE
GROUND PLANE: PHOS BRONZE



DESCRIPTION:
0.8mm Q-RATE RIGHT ANGLE SOCKET ASSEMBLY
DWG. NO.
QRF8-XXX-XX-X-RA-GP-XX
BY: R MUSSER 09/19/2008 SHEET 1 OF 5

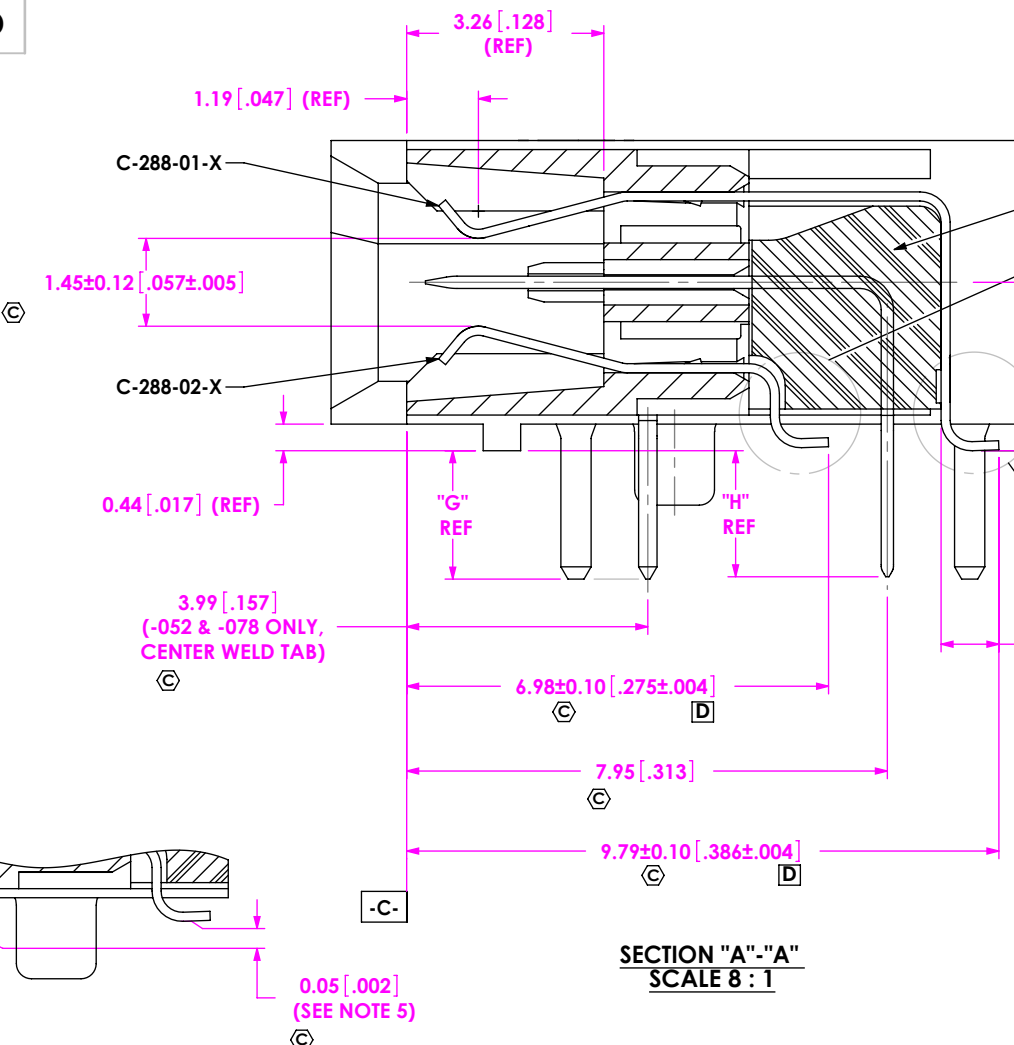


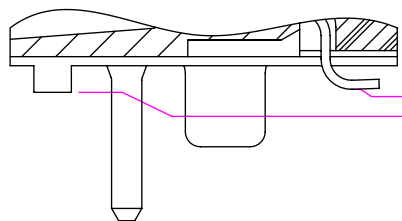
TABLE 4

No OF POSITIONS	BOTTOM ROW STRAIGHTNESS	TOP ROW STRAIGHTNESS	COPLANARITY
-026, -052, -078	0.10 [0.004]	0.10 [0.004]	0.15 [0.006]

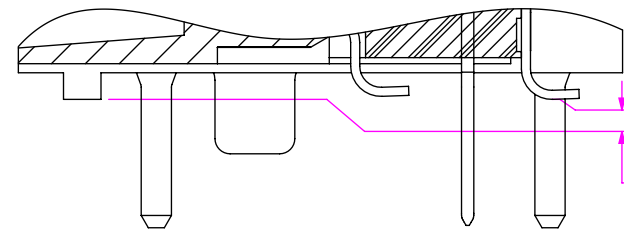
TABLE 3

LEAD STYLE	"G"	"H"
-01	1.33 [0.052]	1.29 [0.051]
*-02	2.12 [0.083]	2.08 [0.082]

(* = NOT TOOLED)



BOTTOM ROW - TAIL DETAIL 'L'
(LOCATE ASSY ON DATUM -C- FOR MEASUREMENTS)



TOP ROW - TAIL DETAIL 'M'
(LOCATE ASSY ON DATUM -C- FOR MEASUREMENTS)

SECTION "A"- "A"
SCALE 8 : 1

TABLE 2

No OF POSITIONS	"A"	"B"	"C"	"D"	"E"	"F"
-026	31.35 [1.234]	20.00 [0.787]	28.45 [1.120]	25.80 [1.016]	24.52 [0.965]	30.00 [1.181]
-052	56.15 [2.211]	44.80 [1.764]	53.25 [2.096]	50.60 [1.992]	49.32 [1.942]	54.80 [2.157]
-078	80.95 [3.187]	69.60 [2.740]	78.05 [3.073]	75.40 [2.969]	74.12 [2.918]	79.60 [3.134]

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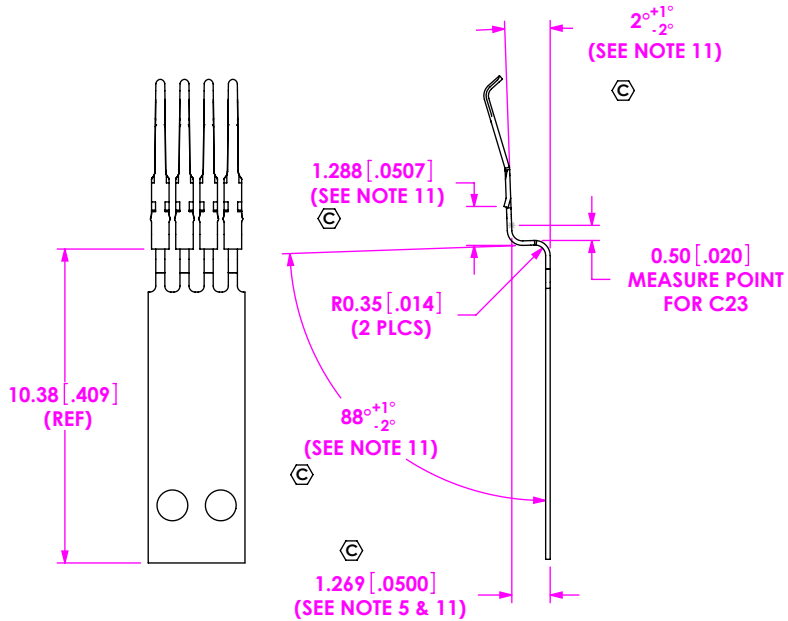


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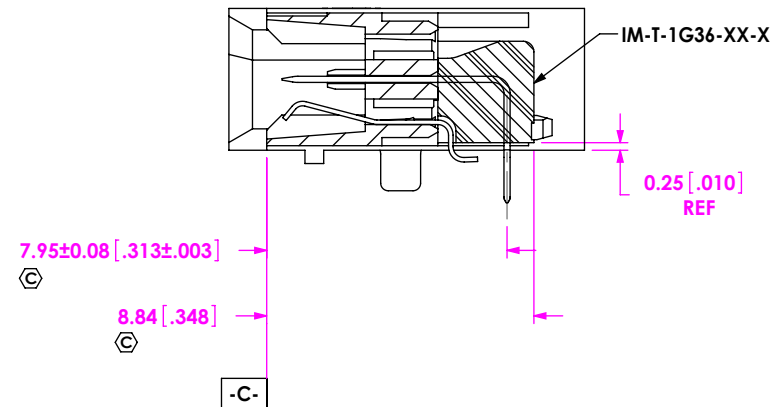
DESCRIPTION:
0.8mm Q-RATE RIGHT ANGLE SOCKET ASSEMBLY

DWG. NO.
QRF8-XXX-XX-X-RA-GP-XX

BY: R MUSSER 09/19/2008 SHEET 2 OF 5

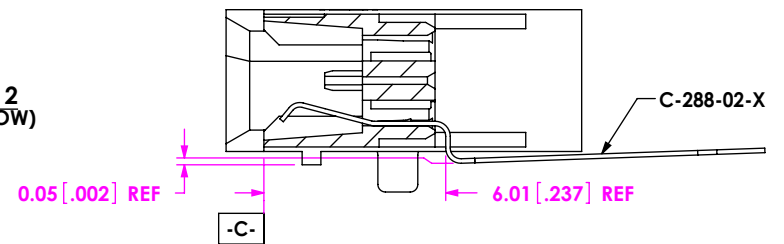


IN PROCESS 1
 [D] (FORM CONTACT C-288-02-X)



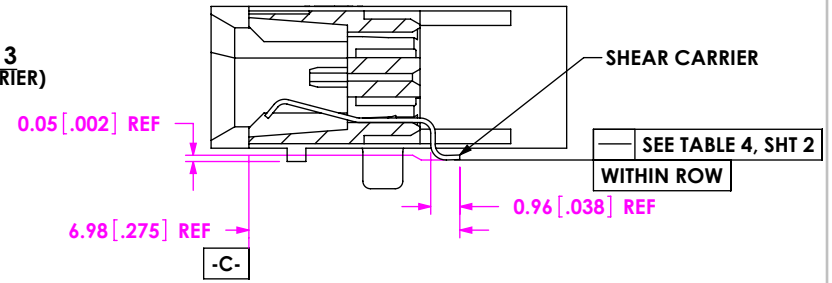
IN PROCESS 4
 (FILL OVER MOLDED GROUND PLANE)
 (IM-T-1G36-XX-X)

IN PROCESS 2
 (FILL BOTTOM ROW)



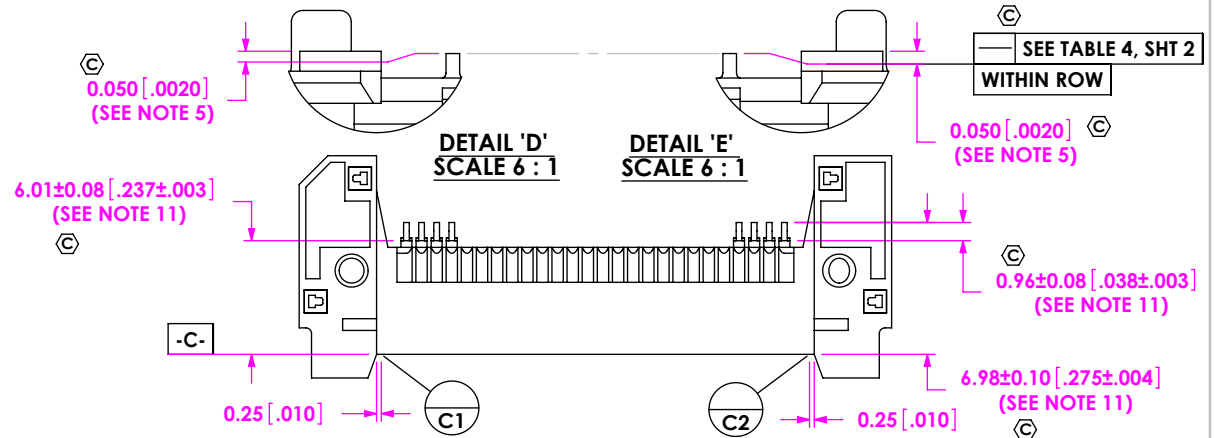
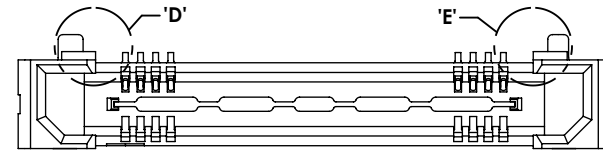
(SEE INSPECTION VIEW 1 FOR ASSEMBLY ORIENTATION AND CPC'S)

IN PROCESS 3
 (CUTOFF OF CARRIER)



(SEE INSPECTION VIEW 1 FOR ASSEMBLY ORIENTATION AND CPC'S)

INSPECTION VIEW 1
 (SEE NOTE 12)



INSPECTION FOR IN PROCESS 2 & 3
 (CARRIER NOT SHOWN FOR IN PROCESS 2 INSPECTIONS)

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SHEET SCALE: 4:1



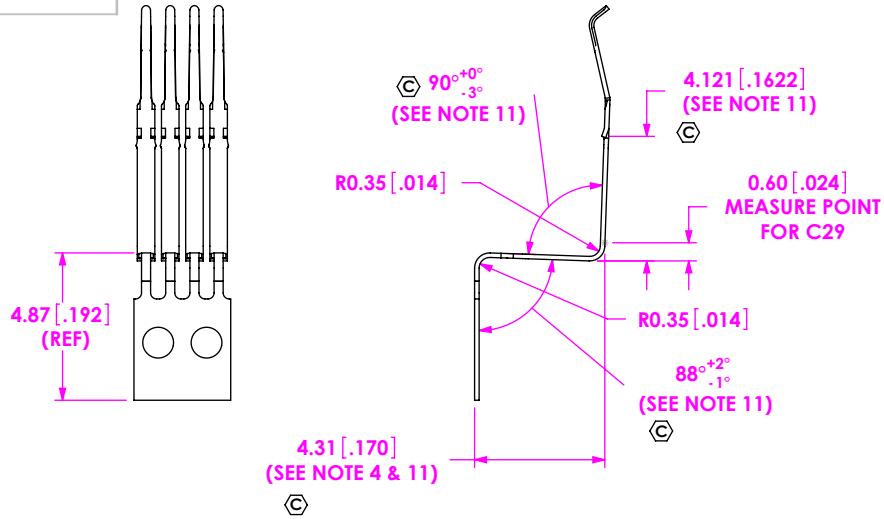
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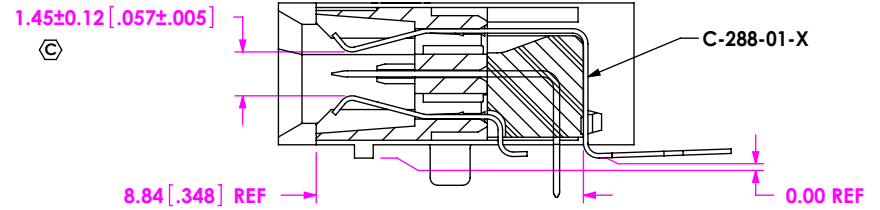
DWG. NO.
QRF8-XXX-XX-X-RA-GP-XX

BY: R MUSSER 09/19/2008 SHEET 3 OF 5

REVISION D

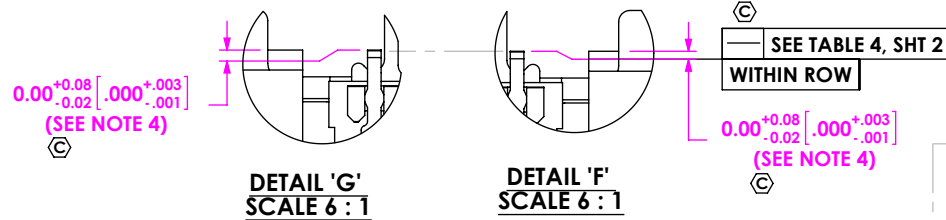
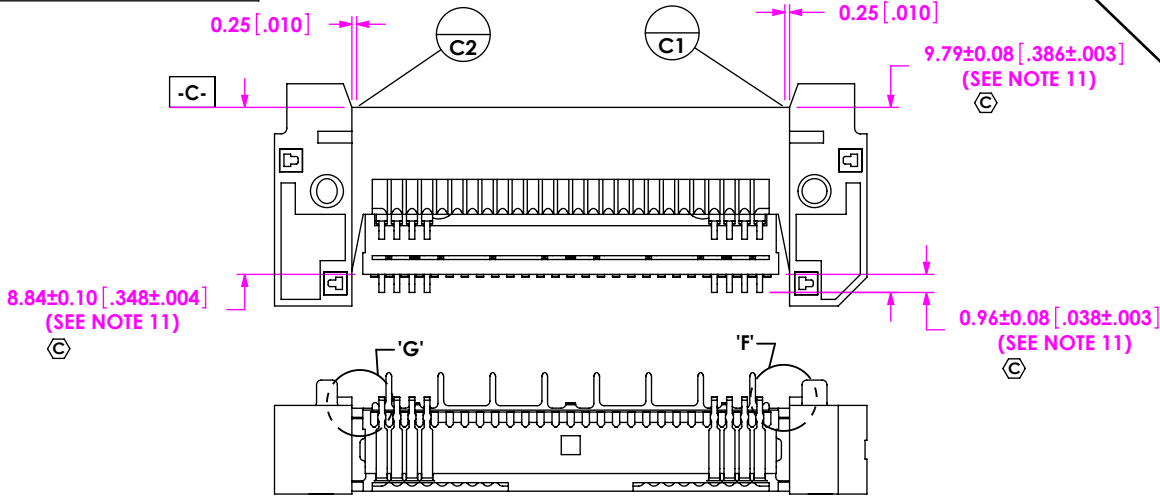


IN PROCESS 5
D (FORM CONTACT C-288-01-X)

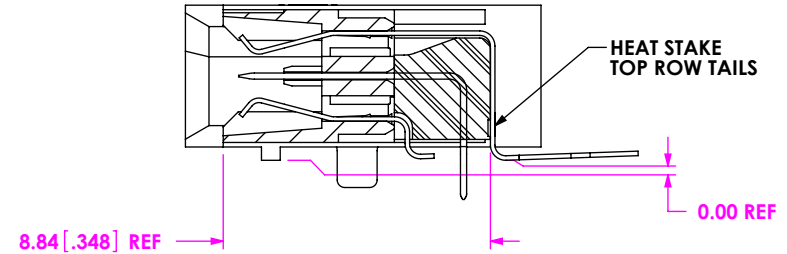


IN PROCESS 6
(FILL TOP ROW)
 (SEE INSPECTION VIEW 2 FOR ASSEMBLY ORIENTATION AND CPC'S)

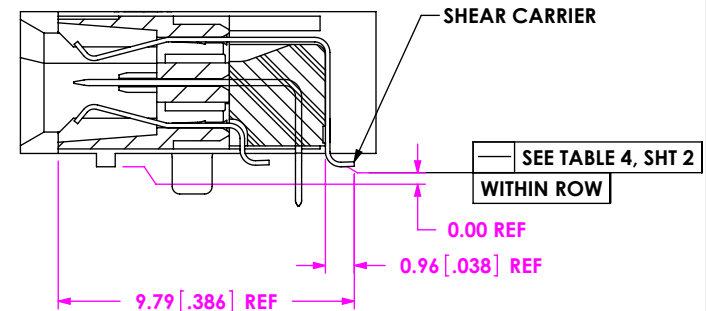
INSPECTION VIEW 2
 (SEE NOTE 12)



INSPECTION FOR IN PROCESS 6, 7 & 8
 (CARRIER NOT SHOWN FOR IN PROCESS 6 INSPECTIONS)



IN PROCESS 7
(HEAT STAKE TOP ROW CONTACTS)
 (SEE INSPECTION VIEW 2 FOR ASSEMBLY ORIENTATION AND CPC'S)



IN PROCESS 8
(CUTOFF OF CARRIER)
 (SEE INSPECTION VIEW 2 FOR ASSEMBLY ORIENTATION AND CPC'S)

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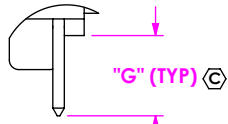
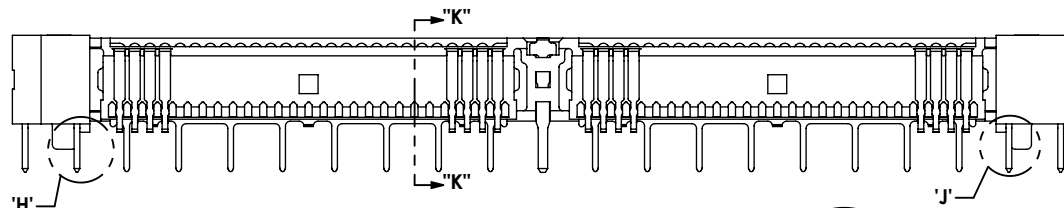


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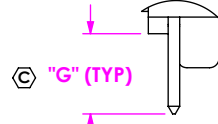
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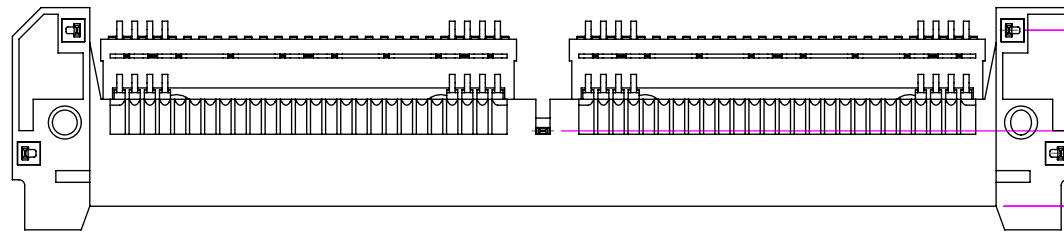
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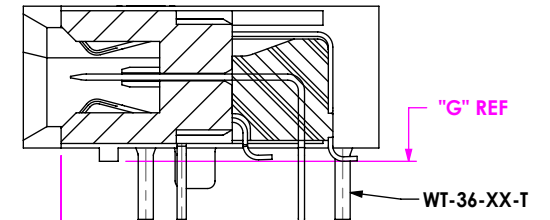
DETAIL 'H'
SCALE 5 : 1



DETAIL 'J'
SCALE 5 : 1



IN PROCESS 9
(FILL WELD TAB)
(WT-36-XX-T)



SECTION "K"-"K"
SCALE 4 : 1

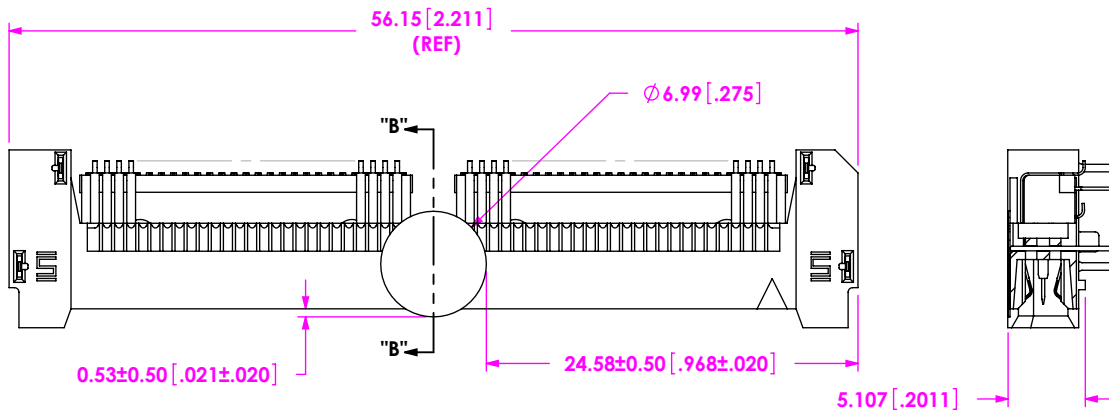


FIG 2
-K OPTION
(USE K-500-300)
(ONLY FOR QRF8-052-02-X-RA-GP-K SHOWN)
(SOME DETAIL REMOVED FOR CLARITY)

SECTION "B"-"B"
SCALE 2 : 1

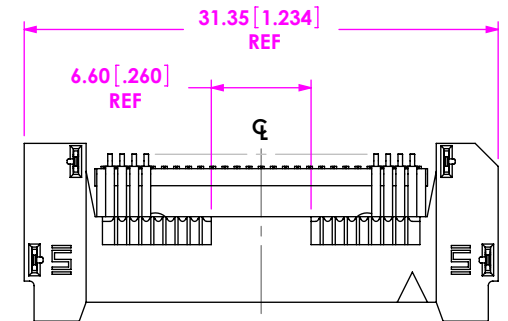


FIG 3
(QRF8-026-02-X-RA-GP SHOWN)
(SOME DETAIL REMOVED FOR CLARITY)

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